

Work Order ID 68999

Wednesday, April 27, 2011 8:28:38 AM



Page 1

Item ID: D3389-1

Accept



Setup Start



Revision ID:

Item Name: Web

Stop



Start Date: 4/27/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/27/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: *mf* Date: *11-04-27*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3389	Rev D

100

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Pick D2500-3-100
2- Deburr
3- Locating from deburred end, drill pilot holes using DT8785 as per dwg D3389. Scribe cut line.
4- Cut to finished length
5- Open holes to finished size as per dwg D3389
6- Deburr

SAP 11-04-27

110

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

11-4-27



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

DP

11-4-27

130 QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4.0

BEU/04/27

140 Identify as per dwg & Stock Location: 4/6

0.00



Packaging

Memo

0.00

Packaging

DP

11-4-27

④

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Revision ID:

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Item Name: Web

Start Date: 4/27/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/27/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/28

MF
11-04-28

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Picklist Print

Wednesday, April 27, 2011 8:28:35 AM

Page 1

Work Order ID: 68999



Parent Item: D3389-1



Parent Item Name: Web


Start Date: 4/27/2011

Required Date: 4/27/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 05.08.31 New issue KJ/JLM
IPP Rev:B 06-02-08 As per Rev C JLM
IPP Rev:C 07-11-13 ECN 1056 Rev D dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-3-100 		Manufactured	No			100	Each	165.0000	1	4			

Ext'n - 'I' Beam Web 4"

Location

LG

51957

66298

Loc Qty

165

4

161

Loc Code

4 11-4-27

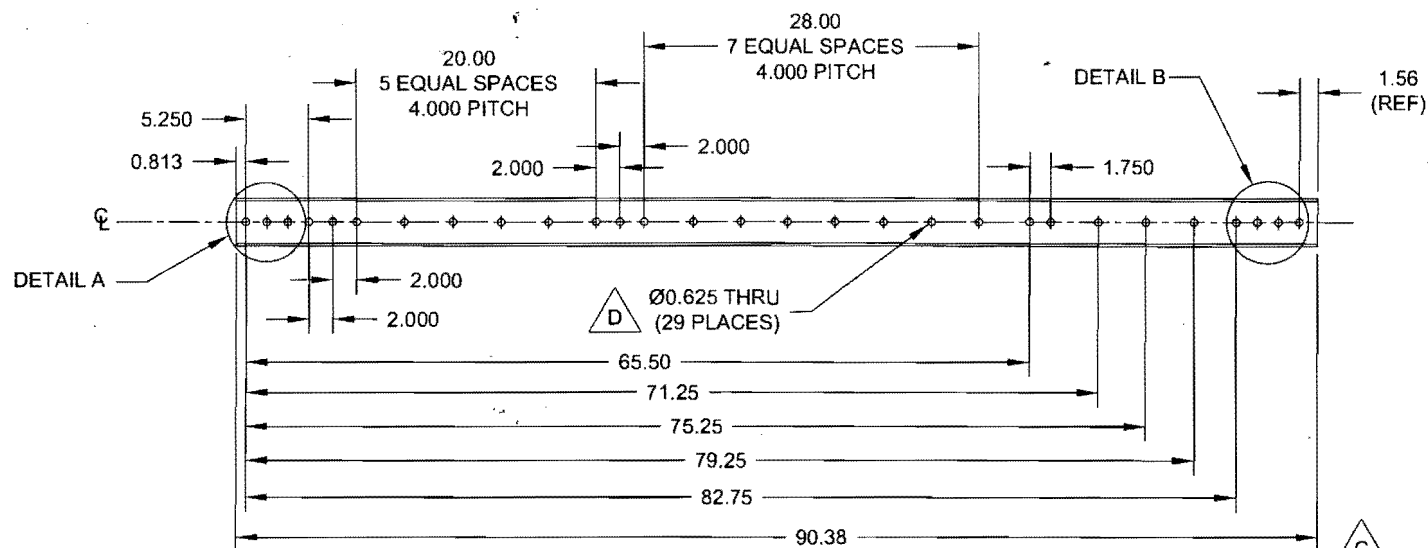
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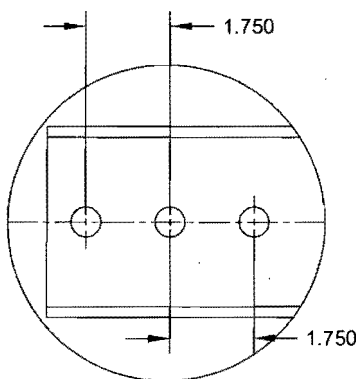
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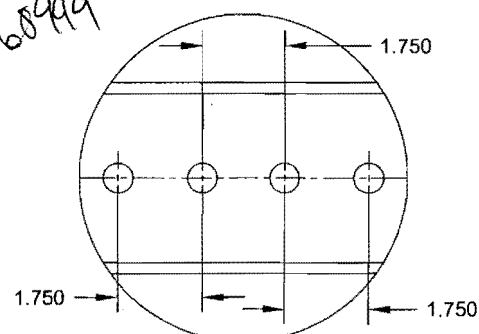
NOTE: Date & initial all entries



D3389-1 412 WEB



DETAIL A
SCALE 2:5



DETAIL B
SCALE 2:5

NOTES:

- 1) MATERIAL: MAKE FROM D2500-3 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.6 lbs

RELEASED
07.11.06 14D

D	REVISE HOLE DIAMETER FROM $\varnothing 0.257$ TO $\varnothing 0.625$, ZONE D4; REFORMAT DRAWING	PH	07.10.09
C	DECREASE OVERALL LENGTH, MODIFY HOLE	PH	06.01.23
B	UPDATE DIMENSIONING	PH	05.06.13
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.09		

DART AEROSPACE USA, INC	
PORT HADLOCK, WA	
DRAWING NO. D3389	REV. D
TITLE 412 WEB	SHEET 1 OF 1
SCALE 1:10	

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